



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.0110

Job Sheet 204978



Part No: 647.0110

Job Qty: 16 pcs

Part Name: Roof Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.0100 REV.B IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 DD AS PER
DWG REV.B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Waterjet - Flow - 1	16 pcs	2/14/20	2/14/20	0.17	3.20	Waterjet - Flow	20/01/27
120	QC 2	16 pcs	2/14/20	2/14/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	20/01/27
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	16 pcs	2/14/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
140	Outsource - 4 - Anodize	16 pcs	2/14/20		ATG001-VC
150	Packaging 2-1 - Receive - B4B	16 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B

DAS

JAN 28 2020 68

9-89

2020-01-30

FEB 24 2020

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
160	QC 6	16 pcs	2/14/20	0.00 0.00	QC 6 - 9	DAS 81 9-89
					QC 6 - 68	DAS 82 9-89
					QC 6 - 61	FEB 24 2020
					QC 6 - 40	
					QC 6 - 81	
190	Packaging 3-1 - Stock - B4B	16 pcs	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 28 9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS 21 9-89
200	QC 21 - SA	16 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	FEB 25 2020
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check)						

140 - Issue P/O to ATG: 45341 AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC6- All purchased or subcontracted products)

190 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	40 sf (2.5 ea)	110-Waterjet - Flow - 1	<u>5180490</u> <u>52116341</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	40	92	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Roof Doubler	20.000Inches ± 0.030	20.030 19.970	20.00	
2	Roof Doubler	14.200Inches ± 0.030	14.230 14.170	14.20	
3	Roof Doubler	14.000Inches ± 0.030	14.030 13.970	14.00	
4	Roof Doubler	5.200Inches ± 0.030	5.230 5.170	5.210	
5	Roof Doubler	21.940Inches ± 0.030	21.970 21.910	21.94	
6	Roof Doubler	25.370Inches ± 0.030	25.400 25.340	25.37	

0.063 ± 0.010

0.063 Plex 12/23/19 2:15 PM Dart.lajeunesse.marie

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Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QS1042)																															
Description Work Order Deviation		Disposition																																	
		Completed By																																	
		Lead hand / Supervisor																																	
		QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																
Crushing	BOM/Route	Grain Direction	Drawing																																
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Mislabeled	Fit/Function	Off-set/Set-up																																	
		Other/Details:																																	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045741



Supplier: ATG001-VC
A.T.G. Industries Inc
260 INDUSTRIELLE STREET
ROCKLAND
ON
K6K 1T2 Canada
Phone: 613-466-4544
Fax: 613-446-4556

Attention: alande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045741
PO Date: 1/30/20
Due Date: 2/17/20
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2020-02-12

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	206082		D3811 Rev C	Bushing : Various STC's ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR 1C OR II OR IIB CLASS 2 C OF C IS REQUIRED	Firmed - X24		2/17/20	24 pcs	0 pcs	24 pcs	\$3.49/pcs	\$83.76
												FEB 13 2020
2	197463	RBE350A93-3501-20	RBE350A93-3501-20 Rev E	(Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3501-20 Rev. E -Certificate of Conformity is required	Firmed - X15		2/17/20	15 pcs	0 pcs	15 pcs	\$3.49/pcs	\$52.35
												FEB 13 2020
3	203795		D5583 Rev A	Radius Block : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5583 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed - X36		2/10/20	36 pcs	0 pcs	36 pcs	\$5.27/pcs	\$189.72
												FEB 14 2020

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PURCHASE ORDER

POHB045741



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	205082	6-7.1812	6-7.1800 Rev NC	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed - X20		2/17/20	20 pcs	0 pcs	20 pcs	\$7.57/pcs	\$151.40
								FEB 24 2020				
5	205404	D5582-1	D5582 Rev A	Aft Angle : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5582 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed - X8		2/10/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36
								FEB 14 2020				
6	205408	D5589-1	D5589 Rev B	Gusset, Outboard LH : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5589 2- Prime Grey as per Dwg. QSI 005,4.2.1.3.2 Certification of Conformity is required.	Firmed - X8		2/10/20	8 pcs	0 pcs	8 pcs	\$6.82/pcs	\$54.56
								FEB 14 2020				
7	204677	RBW6405G00332-33-11	RBW6405G00332-3G Rev 5	Pointer (Outsource process- Anodize per QSI017 4.1.10.1) -Issue PO STRIP and re-anodize -ANODIZE COLOR CLEAR, PER IAW MIL- A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed - X6		2/17/20	6 pcs	0 pcs	6 pcs	\$3.49/pcs	\$20.94
								FEB 13 2020				



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PURCHASE ORDER
POHB045741



Line Item	Job	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	204978	647.0110	647.0100 Rev B Roof Doubler : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X16 DAS 82 9-89	-	2/17/20	16 pcs	0 pcs	16 pcs	\$43.72/pcs	\$699.52
9	205406	D5585-1	D5635 Rev A Stringer, LH Fwd : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5585 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed X8	-	2/17/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36
10	204982	647.0113	647.0100 Rev B Strut Doubler : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X24	-	2/17/20	24 pcs	0 pcs	24 pcs	\$12.47/pcs	\$299.28
11	205407	D5588-1	D5588 Rev A Stringer, RH Aft : Various STC's Issue P/O: 1- Anodize Black per MIL-A-8625, Type II, Class 2 as per Dwg. D5588 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed X8	-	2/17/20	8 pcs	0 pcs	8 pcs	\$7.42/pcs	\$59.36



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K6A 1K7
Canada

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PURCHASE ORDER POHB045741



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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Grand Total: \$1,729.61

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 data notification by supplier
A043 retention of quality documents

A048 counterfeit part avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/12/20 12:53 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919630

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

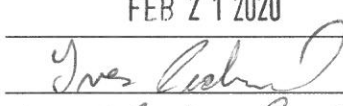
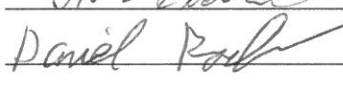
Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 647.1812 Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batcj/Lot#: 5236137 Job: 26882 PO: POHB045741	Rev: A Expiry Date: 05/29/2021 Line: 4	
16 ea	Part: 647.0110 Roof Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5236137 Job: 26886 PO: POHB045741	Rev: B Expiry Date: 05/29/2021 Line: 8	 DAS 82 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: FEB 21 2020 Certified Signature:  Receiver Signature:  A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED

FEB 21 2020

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919630

Date: 21-Feb-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	RECEIVED FEB 21 2020 DART AEROSPACE LTD.	
	Made in Canada.	